

10/23/2008 THU 14:03 FAX 613 632 4443 DART HELICOPTER SERVICES → DAS - LINDA

001/001

Bid 23/10/2008 1627

METAUX SOLUTIONS (MONTRÉAL) INC.
2108, 32E AVENUE
LACHINE, QUEBEC
H8T 3H7 Tel : (514) 633-8010

Sales Rep. : ÉRIC
Reference : LINDA LACELLE
Expiration Date : 22/12/2008

Customer : 6323336

Ship To :

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Same

Fax : 1 (613) 632-4443

Item No.	Description	Qty.	Price	Total	Tx
SH123	303 HEX .500 9 X 12'	108	8.30	896.40	A
	OU				
SH123	303 HEX .500 17 X 12'	204	7.69	1 568.76	A
	DELIVERY APPROX 1 WEEK				
	F.O.B MONTREAL				
	THANKS,				
	ERIC KAEHLERT.				

A) Regist :

Subtotal	2 465.16
TPS :	123.26
Total :	2 588.42

OUTOKUMPU

Certificate of Test

* CERTIFICATION *

HEAT E50377

ORDER 0496191/001 SON 28063C BOL 0149304 TAG 1851525 05/07/08

SHIP TO:

Dart Aerospace Ltd

P.O 7447

PIS 56842

01-40367

5/07/08

CUST# CASTLE01

CUST TAG# IAC 4901

ITEM DESCRIPTION

GRADE 303

Size 303 CDA HEX BAR 1/2 STD

Ship Condition A

Sodutoy

Country of Melt: BRI

Country of Mfg.: USA

NAPTA Country of Origin is Country of Melt

Total Bundles 1

SON Weight

2200

SPECIFICATIONS

MFG TO FINISHED BAR IN THE USA FROM BILLETS IMPORTED FROM BRITAIN

AMS 5640U TYPE I

ASTM A484 06B

ASTM A582 05

DIN 50049/EN 10204 3.1B

SOLUTION ANNEALED CONDITION

FREE OF CONT. CARBIDE NETWORK

AISI-303, UNS S30300, SAE30303

NO WELD REPAIR

UNS S30300, AISI 303

FREE OF MERCURY CONTAMINATION

AM CASTLE 3303-11 R27

MECHANICAL & OTHER TESTS

Test Condition A

Harness as shipped 230 HBW

Harness as shipped 97 HRBS

Harness as converted from tensile

Grain size 8.5

Micro OK

Intergranular corrosion OK

Tensile strength, KSI (MPa) 111.0 { 765)

0.2% Yield Strength, KSI (MPa) 98.5 { 679)

Elongation % in 4D 37.0

Reduction of area % 55.0

CHEMICAL COMPOSITION

Carbon (C)	.043	Manganese (Mn)	1.740
Phosphorus (P)	.028	Sulphur (S)	.338
Silicon (Si)	.430	Chromium (Cr)	17.250
Nickel (Ni)	8.660	Cobalt (Co)	.119
Copper (Cu)	.422	Moly (Mo)	.450
Nitrogen (N)	.051	Columbium (Cb)	.001
Titanium (Ti)	.003	Aluminum (Al)	.003
Tin (Sn)	.012	Boron (B)	.001
Tantalum (Ta)	.002	Vanadium (V)	.070
Columbium/Tantalum (Cb+Ta)	.003		
Iron (Fe)	Balance		
Melt Practice	EAF		
Refining Practice	AOD		
De-long Ferrite	2.0		

DATE RCVD 5/9/08
IAC 4901
APPROVED BY

Knowingly & willfully falsifying or concealing a material act on this form, or making false, fictitious or fraudulent statements or representations herein could constitute a felony punishable under federal statutes.

We hereby certify that the test results shown in this report are correct and accurate as contained in the records of the company and are in compliance with the specifications, codes, and standards listed above.

M.F. Marcanio, Quality Manager

M.F. Marcanio

'X SOLUTIONS (MONTRÉAL) INC.
5 AVENUE
LACHINE, QUEBEC
H8T 3H7

Tel.: (514) 633-3010

Customer: 6323338

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Shipping Order

24/10/2008

Order : 56842
Reference : 7447
Bid : 1627
Ship : NOTRE CAMION / OUR TRUCK

TST / collect

Ship To

Same

Tel.: 1 (813) 632-3338

Item No.	Description	Qty.	Qty. Delivered	B/O Qty
SH123	303 HEX .500 17 X 12'	204	204	0

F.O.B MONTREAL.

CERTIFICATE REQUIRED

EK

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____

Shipping Order No. 2400003

NETWIX SOLUTIONS (MONTREAL) INC.
2105, SZE AVENUE
LACHUTE, QUEBEC
H9T 3H7

Tel. 514-632-3330

Customer: 6323330

DART AEROSPACE LTD
1270, ABERDEEN STREET
HALIFAX, NS, CANADA
B3H 1K7

Same
Tel.: 1(902) 832-3330

Item No.	Description	QTY.	QTY. Available	PO#
SM103	303 HEX, 500 17 X 12'	✓ PPH/03	204	8

F.O.B MONTREAL

CERTIFICATE REQUIRED

EX

Ref:

Shipping
Reference No:
Merchandise Received

DART

Purchase Order

FAXED
(3/08/1002)

Date Oct 24, 2008	Page 1
Purchase Order Number PO00007447	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Metaux Solutions
2108, 32e Avenue
Lachine, QC H8T 3H7
Phone (800) 558-8858
Fax (514) 633-8044

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MET002	Oct 24, 2008	N30	yours	Oct 31, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
204.0000	M303H0500	303 HEX BAR .500 Comments: MATERIAL: AISI 303 HEX BAR NOTE: AISI 304/316 NOT ACCEPTABLE	31/10/2008	No	7.690000	f	1,568.76

Comments: <i>Please fax packing slip + material cert</i>	Tax Summary: GST 78.44 GSTME 0.00 GSTND 0.00	Less: included tax 0.00	
		Subtotal 1,568.76	
		Total tax 78.44	
		Total purchase order in CAD Dollars 1,647.20	

Entered By: *L* CLAVOIE

Approved By: *u*

*thanks
Chantal.*

Dart Aerospace Ltd**Receiving Slip**

Date Nov 5, 2008	Page 1
Receipt Number RCP00009350	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Purchase From:

Metaux Solutions
2108, 32e Avenue
Lachine, QC H8T 3H7

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number VC-MET002	PO Number PO00007447
-----------	-------------	---------	----------------------------	-------------------------

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303H0500	303 HEX BAR .500 NOTE: AISI 304/316 NOT ACCEPTABLE MATERIAL: AISI 303 HEX BAR B/N109778	204.0000	f	7.690000	1,568.76	Nov 05, 2008

Comments:



Métaux Solutions inc.
L'alliage de qualité et de rapidité !

2108, 32e Avenue t (514) 633-8010
Lachine, Québec f (514) 633-8044
H8T 3H7 1 800 558-8858
info@metauxsolutions.com
1320 C, Volta t (450) 641-3330
Boucherville, Québec f (450) 641-3332
J4B 6C6 1 800 967-2003

Customer: 6323336

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Invoice	DATE 31/10/2008	N°/NO. 97982
---------	--------------------	-----------------

Sales Rep. : ÉRIC
Order : 56842
Reference : 7447
Terms : NET 30 JOURS / NET 30 DAYS
Ship : TST

Ship To :

Same

Tel.: 1 (613) 632-3336

Item No.	Description	Ord	Inv.	B/O Qty	Price	Total	Tx
SH123	303.HEX.500 17 X 12'	204	204	0	7.69	1 568.76	A

SHIP TST/COLLECT

CERTIFICATE REQUIRED

EK

RECEIVED NOV 06 2008

Subtotal : 1 568.76

TPS : 78.44

Total : 1 647.20

4) Regist :

TPS : 140667742RT - TVQ : 1017841196TQ0001

Receiving Report

Date: 8/11/03 Batch No: M159778

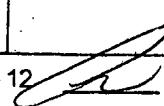
Supplier: MedAire solution Dart P/O: 7447

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection 081105 Yes No N/A
 Work Order _____ N/A N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 

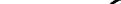
Production/Admin:

Date 08/11/03
 Received/Costing B/P 9350
 Initial CZ

Location _____

DART AEROSPACE LTD	Work Order:	62286
Description: Roll Stand	Part Number:	13822-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:		Preliminary Approval:	
Date:	10/09/30	Date:	10/09/30	Date:	-

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

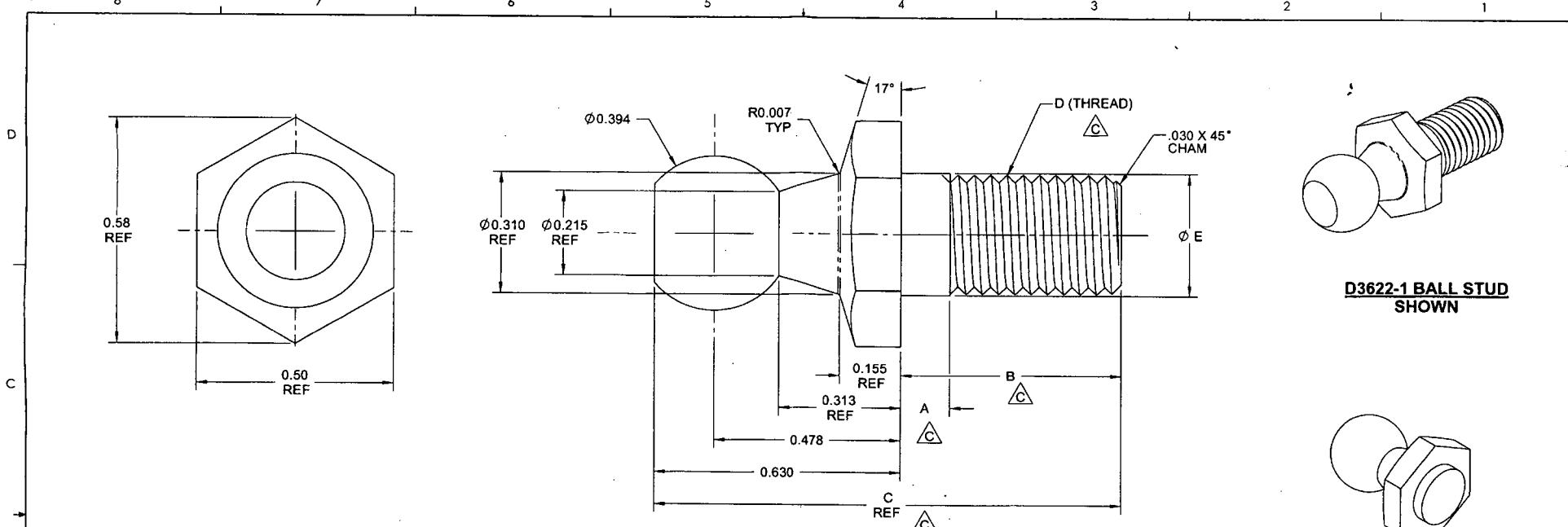
5

4

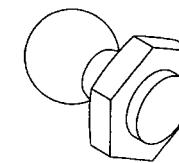
3

2

1



D3622-1 BALL STUD SHOWN



PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN	Ø E MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

XX62254

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED		JPH	10.07.20
B	ADD -3 (SHEET 2)		HS	09.09.18
A	NEW ISSUE		MB	07.04.13
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO. D3622		
MFG. APPR.		REV. C		
APPROVED		SHEET 1 OF 1		
DE APPR.		TITLE	SCALE	NTS
DATE	10.07.20		BALL STUD	

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WRITTEN PERMISSION FROM DART AEROSPACE LTD

8

7

6

5

4

3

2

1

A

B

C

D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 24, 2010 2:44:07 PM

Page 1

Work Order ID: 62286



Parent Item: D3622-5



Parent Item Name: Ball Stud

Start Date: 9/24/2010

Required Date: 9/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500 303 HEX BAR .500		Purchased		No		100	f	125.8880	0.108	0.454737		10/29/2010	

Location	Loc Qty	Loc Code
MAT037	125.888	
109778	101.888	
109846	24	

6 RT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62286

Friday, September 24, 2010 2:44:07 PM



Page 2

Item ID: D3622-5

Revision ID:

Item Name: Ball Stud

Start Date: 9/24/2010 Start Qty: 4.00

Accept



Setup Start



Required Date: 9/30/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: 070

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

AD 10.10.12

(4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

AD 10.10.12

PL 10-10-15
(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62286

Friday, September 24, 2010 2:44:07 PM



Page 1

Item ID: D3622-5

Accept



Setup Start



Revision ID:

Item Name: Ball Stud

Stop



Start Date: 9/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Mf

Date: 10-9-24

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3622	C

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo 0.00
1-TURN AS PER FOLIO F966 & DWG D3622,
FOLIO REV: C
DWG REV: C
2-DEBURR AS REQUIRED

SA 10/09/30

4 Ø

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

SA 10/09/30

4 Ø

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

Jas 10.09.30

4 Ø

